

AMENDMENTS TO THE CLAIMS

The following listing of claims will replace all prior versions and listings of claims in the application.

LISTING OF CLAIMS

1. (Currently Amended) A weld bracket comprising:
a sheet metal surface having a first thickness ~~of less than 1.2 mm~~;
a body portion having a second thickness greater than the first thickness;
a flange portion, having the second thickness, coupled perpendicular to the body portion, said flange portion having a depth being a multiplication factor times the first thickness;
a weldment along a majority of said flange portion attaching said flange portion of the weld bracket to said sheet metal surface; and
wherein the multiplication factor is equal to or greater than the first thickness of the sheet metal surface plus the second thickness of the bracket material and is less than or equal to 5.
2. (Cancelled)
3. (Currently Amended) The weld bracket according to Claim ~~[[2]]~~ 1 further comprising a pair of side triangular support members.
4. (Original) The weld bracket according to Claim 1 wherein the first thickness is less than the second thickness.

5. (Original) The weld bracket according to Claim 1 wherein the bracket has a width between about 1 and 30 mm.

6. (Original) The weld bracket according to Claim 1 wherein the depth is greater than the first thickness plus the second thickness times the first thickness.

7. (Original) The weld bracket according to Claim 1 wherein the depth is less than 5 times the first thickness.

8. (Previously Presented) A weld bracket to sheet metal construction comprising:

a sheet metal base having a first thickness;

a weld bracket having a body portion having a second thickness and a flange portion, said flange portion having a depth which is a multiplication factor of the first thickness;

a weldment portion disposed between a majority of the flange and the sheet metal base, wherein said second thickness is greater than the first thickness; and

wherein the flange portion is coupled perpendicular to the body.

9. (Original) The construction according to Claim 8 wherein the first thickness is less than 1.2 mm.

10. (Original) The construction according to Claim 8 wherein the bracket has a width between about 1 mm and about 30 mm.

11. (Original) The construction according to Claim 8 wherein the depth is greater than the first thickness plus the second thickness times the first thickness.

12. (Original) The construction according to Claim 8 wherein the depth is less than or equal to 5 times the first thickness.

13. (Previously Presented) The construction according to Claim 8 wherein said flange portion has a depth being equal to or greater than the thickness of the base material plus the thickness of the bracket material and less than or equal to 5.

14. (Withdrawn) A method for coupling the weld bracket to a sheet metal component having a first thickness less than 1.2 mm comprising:

providing a bracket having a second thickness which is greater than the first thickness;

forming a flange portion on said weld bracket;

coupling said flange to said metal component;

applying electric current to the flange;

lifting the weld bracket so as to cause an arc between the flange and the base material, wherein liquid weldment material is produced;

forcing the weld bracket into the liquid weldment area; and

removing the electric current.

15. (Withdrawn) The method according to Claim 14 wherein forming a flange portion is forming a flange having a depth being a multiple of the first thickness.

16. (Withdrawn) The method according to Claim 14 wherein forming a flange is forming a flange having a depth of greater than the thickness of the base material plus the thickness of the bracket material times the thickness of the bracket material and less than or equal to 5 times the thickness of the base material.

17. (Withdrawn) The method according to Claim 14 wherein the bracket has a width between 1 and 30 mm.

18. (Withdrawn) The method according to Claim 14 wherein the depth is greater than the first thickness plus the second thickness times the first thickness.

19. (Currently Amended) A weld bracket system, comprising:
a metal base having a first thickness of ~~less than or equal to 1.2 mm~~;
a bracket formed of sheet metal having a second thickness greater than the first thickness, said bracket having a flange having a depth which is a multiplication factor times the first thickness of the metal base; and
a weld between a majority of said flange and said metal base.

20. (Previously Presented) The weld bracket according to Claim 19 wherein the depth is a multiple times the thickness of the sheet metal, said multiplication factor being between the first thickness plus the second thickness and 5.

21. (Previously Presented) The weld bracket according to Claim 19 wherein the multiplication factor is between about 2 and about 3.

22. (Previously Presented) The weld bracket according to Claim 19 wherein the second thickness is between greater than or equal to 0.5 mm and 5 mm.

23. (Previously Presented) The weld bracket according to Claim 19 wherein the first thickness is between greater than or equal to 0.5 mm and about 1.2 mm.

24. (Previously Presented) The weld bracket according to Claim 1, wherein the sheet metal surface is part of an automotive vehicle.

25. (Cancelled)

26. (Previously Presented) The construction according to Claim 8, wherein the sheet metal base and the weld bracket are parts of an automotive vehicle.

27. (Previously Presented) The weld bracket according to Claim 19, wherein the metal base is part of an automotive vehicle.

28. (Currently Amended) A weld bracket system comprising:
a metal sheet having a first surface, a second surface ~~and a~~ having a first
~~thickness of less than 1.2 mm;~~
a metal weld bracket having a body portion and a flange portion attached to said body portion at substantially a right angle, said flange portion and said body portion having a thickness greater than the first thickness and no greater than 5 mm;
a weld connecting said first surface of said metal sheet to said flange portion of said weld bracket, said weld disposed along a majority of said flange portion of said weld bracket; and
wherein a thickness of said metal sheet plus a thickness of said body portion of said metal weld bracket is less than or equal to five times said thickness of said metal sheet.

29. (Cancelled)